

Work Order ID 60418

July 7, 2010 11:13:13 AM



Page 1

Item ID: D119-647-011

Accept



Setup

Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 7/07/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: CL Date: 10/7/7 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3034

Rev A1

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-647-011 CHG 002

8/10/07/29

[Signature] BG 10/07/29

160



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

10/7/29 SP (4x) SD

170



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

8/10/07/29

(4x)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D119-647-011

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Item Name: Bearpaw

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Customer:

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Run

Start



Stop



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-647-011

Location: 14PPP Rev: 15

10/7/09 4259

190



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/30 4259
PL 10-729
(H)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60418

Parent Item: D119-647-011

Parent Item Name: Bearpaw

Start Date: 7/07/10

Start Qty: 4.00

Required Date: 7/14/10

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-02 JLM
 IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC
 IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC
 IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3034-1 Bearpaw		Manufactured	No			170	Each	0.0000	2	8			
D2182B Rubber Cushion		Manufactured	No			170	f	254.3952	2.75	11.57895			

Location	Loc Qty	Loc Code
ST402A	9.67	
30872	9.67	
ST410	244.7252	
52649	244.7252	

cut to 5.5" per dwg D2182 (D2182B055) {QTY 6}

D2274 Radius Block		Manufactured	No			170	Each	357.0000	12	48			
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Location	Loc Qty	Loc Code
ST010	357	
57912	137	
59108	220	

D2529 Washer		Manufactured	No			170	Each	338.0000	12	48			
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Location	Loc Qty	Loc Code
ST017	338	
58568	338	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification , Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60418

Parent Item: D119-647-011

Parent Item Name: Bearpaw

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2947 Manufactured No 170 Each 92.0000



Clamp

Location

Loc Qty

ST457 92

55756 92

Loc Code

AN4-15A Purchased No 170 Each 389.0000



Bolt

Location

Loc Qty

ST358 389

114784 89

115108 300

Loc Code

AN960JD416 NAS1149D0463J Purchased No 170 Each 16.0000



Washer

Location

Loc Qty

ST351 16

108827 16

Loc Code

MS21042L4 Purchased No 170 Each 4,412.000



Nut

Location

Loc Qty

ST300 4400

113422 68

114523 28

114718 304

114784 2000

115108 2000

Loc Code

ST356 12

108145 12



6

124

10/2/29sf



12

148

M114615

10/7/29sf



12

48

M115000

10-2-29sf



12

48

10-7-29

SL(42)

July 7, 2010 11:13:12 AM

Shop Packet Print

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skid tubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-647-011 Bearpaw Installation on model A119 aircraft	15.4 lb 7.00 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	173.2 in 4.40 m	2667 in-lb 30.8 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D119-647-011	BEARPAW INSTALLATION
6	D2182B055	RUBBER CUSHION
12	D2274	RADIUS BLOCK
2	D3034-1	BEARPAW
12	D2529	WASHER
6	D2947	CLAMP
12	AN4-15A	BOLT
12	AN960JD416	WASHERS
12	MS21042L4	NUT (OR MS21042-4)

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Revision: 0

32-00-00
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